

Touchup as req'd

Work Order ID 51890

Tuesday, September 08, 2009 3:26:26 PM

Delev 58692



Page 1

Item ID: D350-748-101

Revision ID: BE & 10.06.12

Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009 Start Qty: 1.00

Required Date: 9/29/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPD350-748-101

CHG001

0.00

0.00

8.15/13

For CL 10/04/21

110



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

0.00

0.00

10-1-12

120



QC

Quality Control

QC15- Crosstube Dimensional Check

Memo

0.00

0.00

10.01.13

Work Order ID 51890

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Page 2

Item ID: D350-748-101

Accept



Setup Start



Revision ID: D

Item Name: Crosstube Installation, High Fwd

Stop



Start Date: 9/9/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/29/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Crosstubes

Crosstubes

0.00

Memo

0.00

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-141

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: 107956

AWM 10-1-25

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)

→ 10/1/09

(X)

[illegible]

Tuesday, September 08, 2009 3:26:26 PM



Abstract

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1111

Customer:



Date: _____

150



Outsource process-Cadplate per QSI017 4.1.9.1

0.00

Memo

Issue P/O: 11282
Stress relief at 375° for 5 hours

Stress relief at 375° for 5 hours
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possible Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

0.00

[illegible]

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Ensure certificate of conformity is attached

0.00

Abstract

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

Work Order ID 51890

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Item ID: D350-748-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/29/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 SprayPaint Spray Painting	SprayPaint Memo 1-Prime inside crosstube as per QSI 005 4.2 2-Prime Outside of Tube as per Dart QSI 005 4.2	0.00 0.00				<u>ml</u>	<u>10</u>	<u>04</u>	<u>20</u> ①
190 QC Quality Control	QC14- Inspect Spray Paint Memo Then, Wrap in plastic bag to protect from scratches	0.00 0.00							
200 Crosstubes Crosstubes	Crosstubes Memo 1-Install Ground wire Insert, then insert screw and washer 2-Install Abraison strips as per Dwg D350-748-141 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS	0.00 0.00				<u>ml</u>	<u>10</u>	<u>04</u>	<u>20</u> ①

Work Order ID 51890

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Item ID: D350-748-101

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/29/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
220	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
230	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

S 10/2/20

(70)

10-4-28 SP

S 10/5/13

(80)

HWA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-101 PAR #: NCR 10-026 Fault Category: Cross-tubes NCR: Yes No DQA: 7 Date: 10/05/12
 Resolution: Disposition: QA: N/C Closed: 78 Date: 10/05/17

NCR: 51890		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.05.11		NCR 10-026 - To verify that the tubes are good, per the above NCR. cracking issue.	CP 10.05.12 QSI 042	load test per Darts email ref NCR 10-026	<u>78</u> 10.05.11	CP 10.05.12 QSI 042	<u>78</u> 10.05.12	<u>78</u> 10.05.12
			CP 10.05.12 QSI 042	touchup as necessary replace abrasion strip if necessary	mm 10.05.12	S 10/05/13	<u>78</u> 10.05.12	<u>78</u> 10.05.12

NOTE: Date & initial all entries

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 27, 2010 3:40 PM
To: 'Mike Petsche'
Cc: 'Bill Beckett'; 'L Lacelle'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com
Subject: 350 crosstubes
Mike,

I discussed the 350 crosstube load testing with Bill a little while ago and this plan makes sense to him.

So, my recommendation to clear these crosstubes is to load the fwd crosstubes to 3500 lb and the aft crosstubes to 3000 lb in the deflection test rig and document on the work orders that this test has been completed. Hold max load for 1 minute. Per TP-D350-748-2, these loads represent the maximum load on these crosstubes at gross weight and are below the yield point of the material. I would like to request that Chris Provencal witness these tests and sign off the work orders based on his experience with Dart landing gears. My feeling is that if there is a problem with the parts, it will manifest itself during this load test. I, for one, would feel a lot more confident in testing each crosstube in this manner than relying totally on what Exova has to say. I think it would be very difficult to reach a conclusion on the whole batch on the basis of cracks in two parts from the batch.

I believe that we can accomplish this before next Friday, which also gives us time to hear what Exova has to say in case it has an impact on our decision. So far, what I have seen from Exova shows me that there are fluctuations in the heat treating but the tubes are heat treated to our specification.

For this reason, I believe we should tell DHS that it looks like we will be able to start shipping 350 crosstubes by May 7th pending a successful Engineering test of the material.

David.

Work Order ID 51890

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Item ID: D350-748-101

Accept

Setup Start

Revision ID: D

Stop

Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/29/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-748-101 Location: _____ PPP Rev: <u>B</u>	0.00							
250	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 10-1-11 AUTH WRELEASED u DATE 10-8-13

NCR 10-026

see attached of signed

10/05/17

WME
10-5-14

Picklist Print

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Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D350-748- 141TRNRevD		Manufactured	No			110	Each	4.0000	1.0000			



8-50622 MB 10-01-12

Crosstube Turning Detail

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	4	
37995	1	
37999	1	
40099	1	
40103	1	

ALS4-1032-225

Purchased

No

200

Each

8,753.000 1.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8753	
107441	16	
<u>110768</u>	8737	

ml 10-04-20

Picklist Print

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Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No			200	Each	2,309.000	1.0000			



Washer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2309	
105442	95	
109059	2	
109840	23	
110985	202	
111279	13	
111668	70	
112314	1000	
112369	904	

ml 10.04.20

D2856-400RevA

Manufactured No

200 f

332.4577 1.2432



Abraison Strip



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	122.8077	
42437	44.93	
46543	77.8777	
Main Warehouse		
ST403	209.65	
50593	209.65	

ml 10.04.20

B# 56626

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Work Order ID: 51890

Parent Item: D350-748-101RevD

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3500-1RevC Manufactured No

200

Each

17.0000

4.0000



Saddle

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~~1355605~~ 53792

10-4-28 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

47119

12

47350

5

D3502-1RevB

Manufactured No

200

Each

43.0000

2.0000



Support

*



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

41603

2

42968

2

47120

1

Main Warehouse

ST168

38

50287

38

B#52903

m 10.04.20

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Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-20 		Purchased	No			200	Each	117.3000	2.0000			
Clamp (per MIL-DTL-8783C)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	117.3	
103478	2	
106484	12	
109269	9.3	
110536	10	
111281	34	
112307	50	

ml 10-04-20

MS27039-1-10 	Purchased	No				200	Each	37.0000	1.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	37	
111425	37	

ml 10-04-20

B# 112794

Picklist Print

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Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN4-41A		Purchased	No			220	Each	142.0000	8.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	142	
105940	4	
110363	16	
110731	50	
111424	50	
112082	22	

7/11 10-4-288

AN4-6A		Purchased	No			220	Each	814.0000	16.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	814	
102602	3	
105810	15	
107534	1	
109545	2	
110399	27	
111279	466	
112314	300	

1112933 10-4-28sf

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Shop Packet Print

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Picklist Print

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Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN5-32A

Purchased

No

220

Each

79.0000

4.0000



Bolt



1113/21 10-1-2830

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

79

106242

3

106519

4

110363

17

111916

5

112082

50

Tuesday, September 08, 2009 3:26:35 PM

Shop Packet Print

Page 6

Picklist Print

Page 7

Tuesday, September 08, 2009 3:26:35 PM

Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416	102929	Purchased	No			220	Each	8,758.000	32.0000			



Washer



M113706 10-4-288

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8758

102929

2

105906

4

107321

23

107939

114

108161

553

108827

31

109249

69

110523

340

111279

115

111916

2620

112314

4887

16941

0

Tuesday, September 08, 2009 3:26:35 PM

Shop Packet Print

Page 7

Picklist Print

Page 8

Tuesday, September 08, 2009 3:26:35 PM

Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD516

Purchased

No

220

Each

1,209.000

8.0000



Washer

NA51149 005632



M173706 10-4-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1209

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

359

112314

500

D3501-1RevA

Manufactured

No

220

Each

423.0000

16.0000



Bushing



10-4-28 3P

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

423

45402

19

45918

200

48268

204

15

Tuesday, September 08, 2009 3:26:36 PM

Shop Packet Print

Page 8

Picklist Print

Page 9

Tuesday, September 08, 2009 3:26:36 PM

Work Order ID: 51890



Parent Item: D350-748-101RevD



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L4		Purchased	No			220	Each	8,308.000	24.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Nut

M114108 10-4-2850

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	8308	
107499	5	
110507	266	
111827	5996	
112314	2000	
15924	0	
8182	41	

MS21042L5

Purchased No

220 Each 1,337.000 4.0000



Nut

M114108 10-4-2850

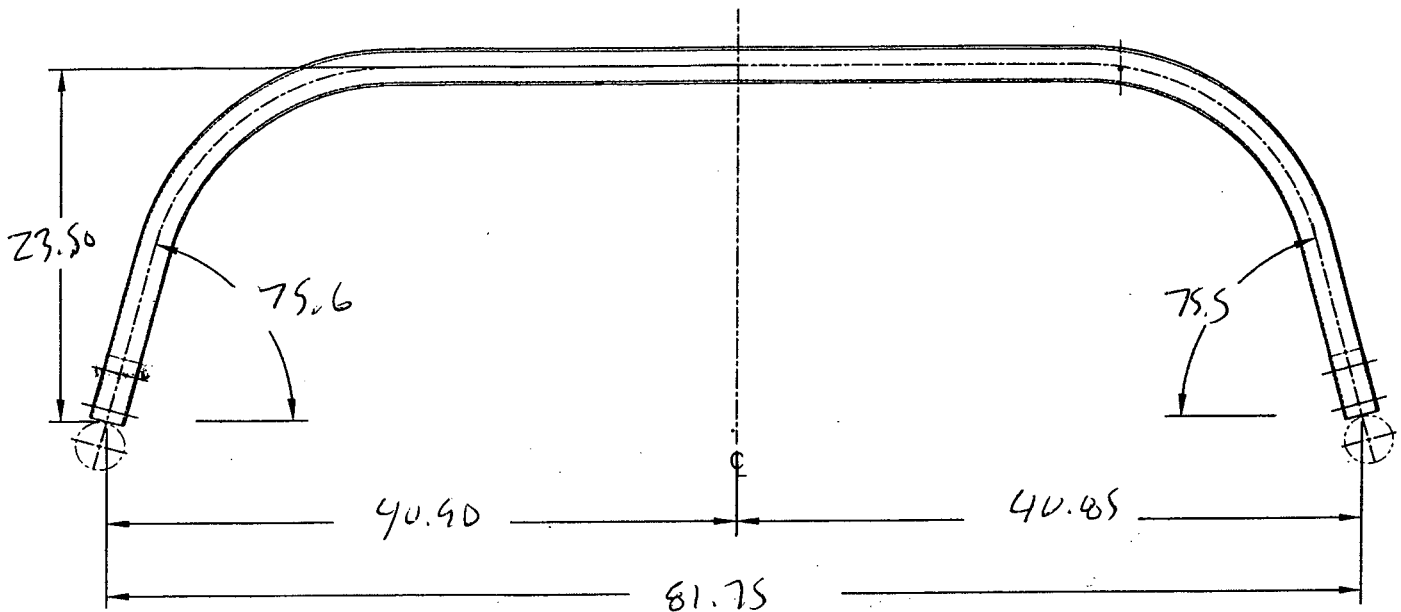
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	1337	
110382	10	
111636	327	
112314	1000	

DART AEROSPACE LTD		Work Order: 51890
Description: Crosstube High Fwd (AS350/355)		Part Number: D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
Twist = 0.244"
Tube is bent high. Acceptable P 10.01.13

QC15 Inspection	P 10.01.13
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

67HS



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 *HA*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

UNDER REVIEW

09.02.05

PER PCR #09.001

D350-748-141 CROSSTUBE:

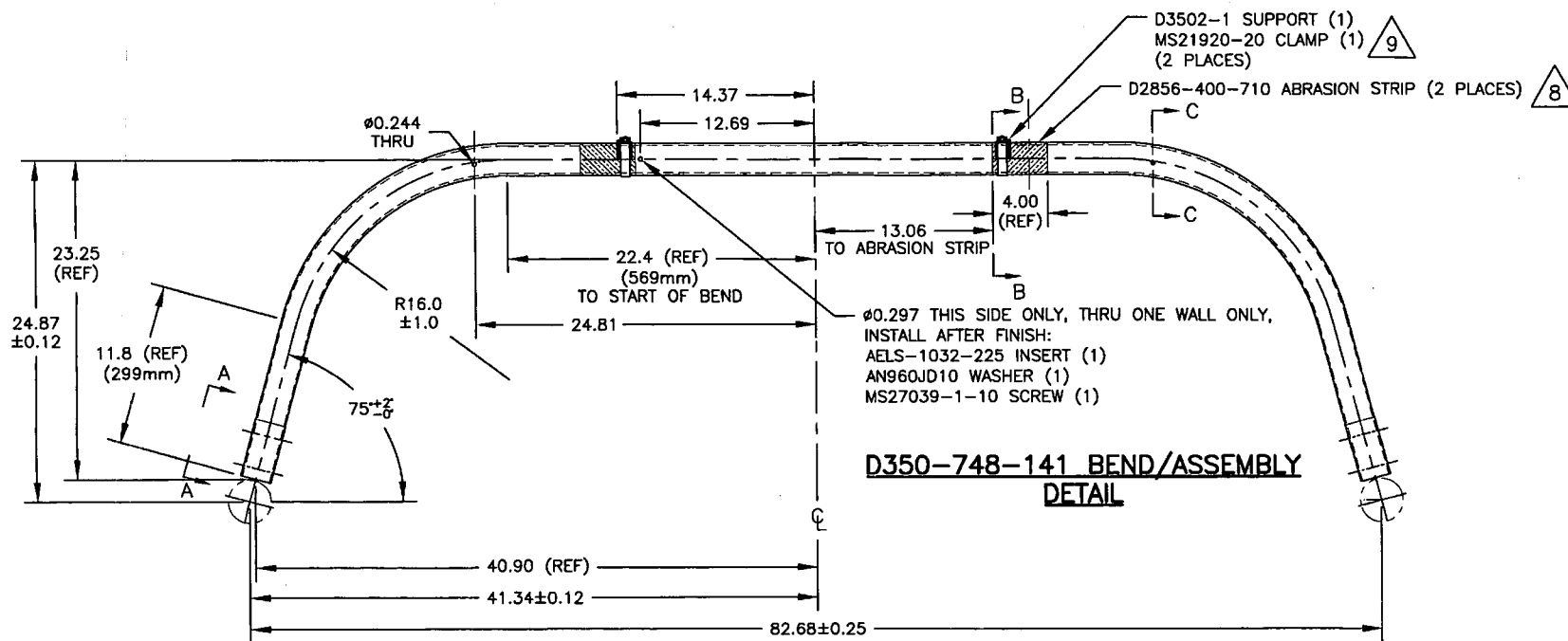
- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

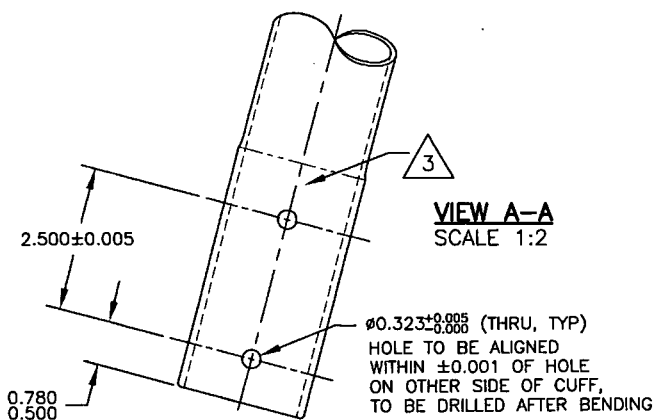
OK 07.10.22

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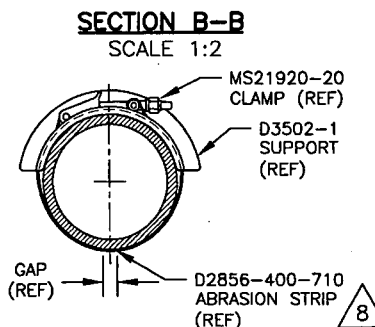
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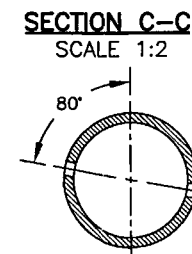
**D350-748-141 BEND/ASSEMBLY
DETAIL**



**VIEW A-A
SCALE 1:2**



**SECTION B-B
SCALE 1:2**



**SECTION C-C
SCALE 1:2**

UNDER REVIEW
09.02.05

UNDER REVIEW
02.16
OK 09.10.22

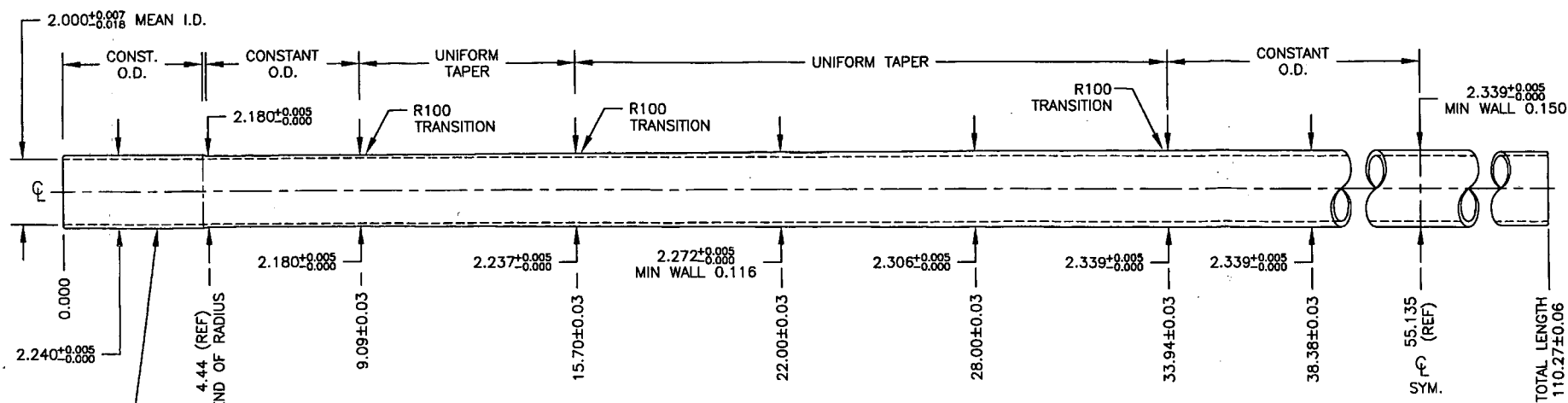
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06.10.31

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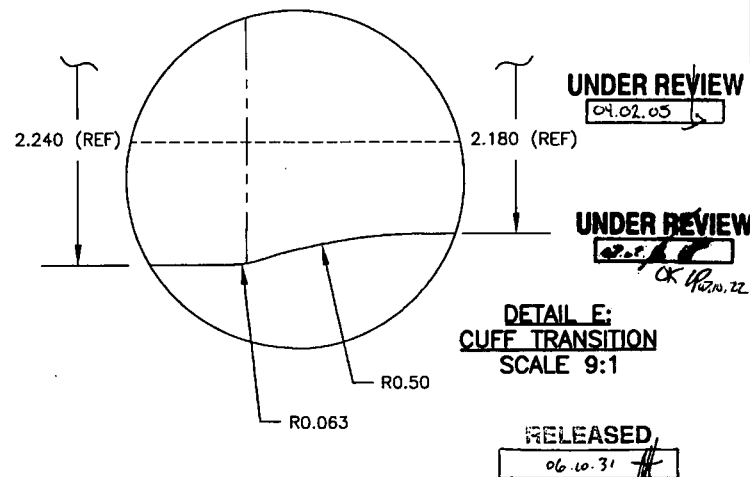
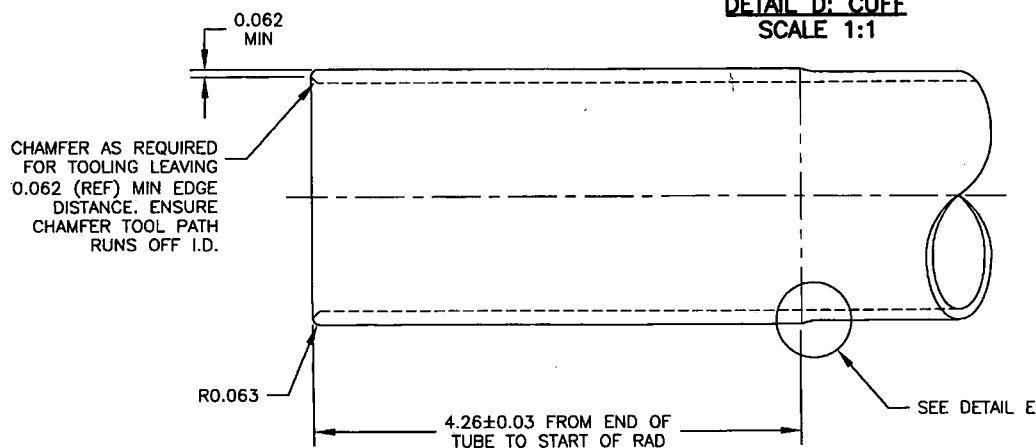
DESIGN	40	DRAWN BY	40	DART	DART AEROSPACE LTD. WILLOWDALE, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI FWD)	D350-748-141	SHEET 2 OF 3
		SCALE	1:8		

wb 51980



D350-748-141 MACHINING DETAIL

DETAIL D: CUFF
SCALE 1:1



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DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)		REV. 0 SHEET 3 OF 3 SCALE 1:3

w/o -51890

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Feb-22-2010

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 93275

INVOICE #: 48326

**CONTRACT OR
PURCHASE ORDER # 513885**

DESCRIPTION: SKID

P/N # d350-748-101

S/N # B51890

QTY

1

**STRESS RELIEF BAKED @ 375 DEG. FOR 5 HRS. BAKE HEAT
CHART #10-116. MPI INSPECTED IAW ASTM-E-1444. CADMIUM
PLATED IAW AMS-QQ-P-416B, TYPE 2 YELLOW, CLASS 1. BAKE
HEAT CHART #10-169.**

8/10/03/01

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:

